

Shp Oct. 26

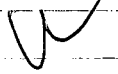
Work Order ID 92237

October-23-12 1:57:59 PM

92237

Page 1

Item ID: D119-647-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 10/23/12 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 10/26/12 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9607	REV A 

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D119-647-013								

160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									

170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS 16 12/10/25

MCS 12-10-25

5x

SP 12-10-24

DAS 16 12/10/25



NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
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Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 92237

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92237

Page 2

Item ID: D119-647-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 10/23/12 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 10/26/12 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

180

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D119-647-013

Location: 014

PPP Rev: _____

0.00

0.00

JD SH 12/10/25

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 12-10-25

MLJ 12-10-25

NCR: Yes / No

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist-Print

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Page 1

Work Order ID: 92237

Parent Item: D119-647-013

Parent Item Name: Bearpaw

Start Date: 10/23/12

Required Date: 10/26/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC
10-23 JLM VERIFIED BY:DD

IPP REV B:AS PER REV B 12-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B055 Clamp Cushion Black 5.5" Long <i>Qty 6 Per Kit</i> <i>LT messen</i> <i>5/2/10/25</i>		Manufactured	No				Each	11.0000	<i>1375</i>	<i>60</i>	<i>30</i>	<i>B86201 sp.</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402A		11							
				68746		3							
				73932		8							<i>Smb</i>
D2274 Radius Block <i>5/5</i>		Manufactured	No				Each	474.0000	<i>112</i>	<i>60</i>	<i>60</i>	<i>sp.</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST008		474							
				86855		6							<i>Smb</i>
				88452		233							<i>60x</i>
				89280		235							
D2529 Washer <i>5/5</i>		Manufactured	No				Each	612.0000	<i>12</i>	<i>60</i>	<i>60</i>	<i>sp.</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST011		612							
				79485		16							<i>Smb</i>
				86909		96							<i>600x</i>
				89356		500							
D2947 Clamp <i>5/5</i>		Manufactured	No				Each	98.0000	<i>62</i>	<i>30</i>	<i>30</i>	<i>sp.</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST456		41							
				86490		1							
				91563		40							<i>Smb</i>
				ST456a		57							
				89138		57							<i>36x</i>

NCR: Yes / No

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Picklist-Print

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Page 2

Work Order ID: 92237

Parent Item: D119-647-013

Parent Item Name: Bearpaw

Start Date: 10/23/12

Required Date: 10/26/12

Start Qty: 5.00

Required Qty: 5.00

D3034-3

Bearpaw

Manufactured No

Each 11.0000

2 10

B91692 SP

Location

Loc Qty

Loc Code

ST

11

87875

1

91394

10

SMB

AN423A

Bolt

Purchased No

Each 19.0000

12 60

43xm 123434

SMB

Location

Loc Qty

Loc Code

ST358

19

122800

19

17x

AN960JD416

Washer

NAS1149D0463J

Purchased No

Each 29.0000

12 60

m/22452 39x

21x m 123248 SP

SMB

Location

Loc Qty

Loc Code

ST351

29

116289

8

119097

21

MS21042L4

Nut

Purchased No

Each 6,822.0000

12 60

SP 12-10-24

Location

Loc Qty

Loc Code

314

1295

122452

1295

ST300

27

119017

20

121444

7

ST314

5500

123021

3000

123248

900

123355

1600

60x

SMB

October-23-12 1:57:59 PM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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REFERENCE ONLY

REFERENCE ONLY
SMB

4.0 PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D119-647-013	BEARPAW INSTALLATION
6	D2182B055	CUSHION
12	D2274	RADIUS BLOCK
12	D2529	WASHER
6	D2947	CLAMP
2	D3034-3	BEARPAW
12	AN4-23A	BOLT
12	AN960JD416	WASHER
12	MS21042L4	NUT



5.0 WEIGHT AND BALANCE

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D119-647-013 Bearpaw Installation	17.6 lb 7.98 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	173.2 in 4.40 m	3048 in-lb 35.1 m-kg

DESIGN	AP	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AP		
CHECKED	<i>gp</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9607	SHEET 3 OF 3
APPROVED	<i>160</i>	TITLE	SCALE
DE APPR.	<i>th</i>	BEARPAW INSTALLATION	NTS
DATE	12.10.10	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

